

**Work Order ID 86008**

June-19-12 2:22:12 PM

**\*86008\***

Page 1

Item ID: D212-664-107

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Item Name: Crosstube Low Standard Fwd

Stop

**\*NS2\***Start Date: 19/06/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: MLJDate: 12/06/19 Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D212-664-147	Rev B (DEO)								

100

**\*100\***

DOCUMENT CONTROL

DC

Document Control

Memo

Photocopy bluefile and create labels as per PPP D212-664-107  
D6019-128 (ID = 2.125") = CHG 002  
D6005-128 (ID = 2.000") = CHG 003**SCRAP****\*110\***

Packaging

Packaging

Memo

Packaging

0.00

0.00

120

**\*120\***

CNC Bend 2

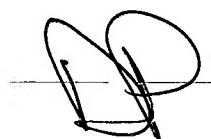
CNC Alpha 160 Bender

BENDING MACHINE - CROSSTUBES

Memo

0.00

Bend tube as per Dwg D212-664-107 using CNC bender program 212-107

 12-7-24 12-7-24PTO 

W/O: 86008

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D212-664-107 PAR #: \_\_\_\_\_ Fault Category: X-tube NCR: Yes No DQA: ✓/✓ Date: 12/08/13  
 Resolution: \_\_\_\_\_ Disposition: Scrap QA: N/C Closed: ✓/✓ Date: 12/08/14

WORK ORDER NON-CONFORMANCE (NCR) \$317								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-7-24	120	Middle wavycut at prog. 5 (usually run up to 10) 1 side wavycut at prog 4 (usually run up to 6 then check) Run Second tube as per fabo tube turned out perfect. RC: Process, NOTE: See attached IRN Deviation	AP 12/08/13 Q2042	Scrap & Destroy	MO 12/8/17	JW 12-8-7	✓/✓ 12/08/13 QSI 042	DAS 16 8-63 2008/02
		Ref: SA - SB - H -						

NOTE: Date &amp; initial all entries

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Item ID: D212-664-107

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**\*NS1\***

Revision ID:

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Stop

**\*NS2\***

Start Date: 19/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	<b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:		Stop	<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC15- Crosstube Dimensional Check	0.00							

**\*130\***

QC

Quality Control

140

**\*140\***

Crosstubes

Crosstubes

Memo

0.00

0.00

Crosstubes

1-Cut tube as per inspection dwg and deburr ends. \*\*\*ensure saw is square\*\*\*

2-Position cuffs on tube ensure proper positioning

3-Drill tube as per dwg using DT8577 location #7 & # 212 ULF using jig  
DT8548 and DT8549 as per QSI 10

4-Transfer drill rivet holes from cuff into tube.

5-Identify cuff position and Batch # on each and identify tube as per dwg D212-  
664-107.

6- Inspect surface damage

7- Deburr and realodine cuff.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Item ID:** D212-664-107**Accept****\*N900040100\*****Setup Start****\*NS1\*****Revision ID:****Stop****\*NS2\*****Item Name:** Crosstube Low Standard Fwd**Start Date:** 19/06/2012 **Start Qty:** 1.00 **\*1\*****Cust Item ID:****Required Date:** 03/07/2012 **Req'd Qty:** 1.00 **\*1\*****Customer:****Reference:****Approvals:** **Process Plan:** \_\_\_\_\_**Date:** \_\_\_\_\_**Tooling:** \_\_\_\_\_**Date:** \_\_\_\_\_**Run Start****\*NR1\*****QC:** \_\_\_\_\_**Date:** \_\_\_\_\_**SPC (Y/N):** \_\_\_\_\_**Date:** \_\_\_\_\_**Stop****\*NR2\*****Sequence ID/  
Work Center ID****Operation  
Description****Set Up/  
Run Hours****Tool ID****Tool #****Plan  
Code****Accept  
Qty****Reject  
Qty****Reject  
Number****Insp.  
Stamp**

180

Outsource process - NDT per QSI038 4.1

0.00

**\*180\***

Outsource2

**Memo** \_\_\_\_\_  
 Liquid Penetrant Inspection as per QSI 038Or  
 Issue P/O: \_\_\_\_\_ LPI as per ASTM 1417  
 Level 2 Attach copy of NDT results to work order

190

Packaging

0.00

**\*190\***

Packaging

**Memo** \_\_\_\_\_  
 Ensure copy of NDT results attached to work order.

200

QC5- Inspect part completeness to step on W/O

0.00

**\*200\***

QC

**Memo** \_\_\_\_\_  
 Inspect for damage & ensure results are as per Dwg D212-664-107

Quality Control

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Item ID: D212-664-107

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**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Crosstube Low Standard Fwd

Stop

**\*NS2\***

Start Date: 19/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Crosstubes	0.00							
<b>*210*</b>	Crosstubes								
	Memo	0.00							
Crosstubes	1-Rivet Cuffs as per Dwg D212-664-147. with Sika flex in Between tube & Cuff A/R SIKAFLLEX -241/-291 BATCH: _____								
215	QC5- Inspect part completeness to step on W/O	0.00							
<b>*215*</b>	QC								
Quality Control	Memo	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Setup Start

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Stop

\*NS2\*

Start Date: 19/06/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
QC:		Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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220

\*220\*

SprayPaint

SprayPaint

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Spray Painting

Memo  
1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME:

Start Time: \_\_\_\_\_  
Finish Time: \_\_\_\_\_

PAINT:

Start Time: \_\_\_\_\_  
Finish Time: \_\_\_\_\_

230

QC14- Inspect Spray Paint

0.00

\*230\*

QC

Quality Control

Memo  
Wrap in plastic bag to protect from scratches

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

Item Name: Crosstube Low Standard Fwd

Stop

\*NS2\*

Start Date: 19/06/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

240

\*240\*

Crosstubes

Crosstubes

0.00

Crosstubes

Memo

0.00

1- Assemble as per Dwg D212-664-147

1-Abrade mating surfaces of support and crosstube with 400 grit sandpaper,  
clean the area with 4105S wash 'n' wipe

2-Install supports with Proseal 890 per DSI9563 and QSI 015

A/R Proseal 890 Batch: \_\_\_\_\_

3- Torque bolts as per dwg

250

QC5- Inspect part completeness to step on W/O

0.00

\*250\*

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID 86008

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\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Crosstube Low Standard Fwd

Stop

\*NS2\*

Start Date: 19/06/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

255

Pick Kit

0.00

\*255\*

Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00

\*260\*

QC

Memo

0.00

Quality Control

270

Packaging

0.00

\*270\*

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D212-664-107

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID 86008

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Item ID: D212-664-107

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Crosstube Low Standard Fwd

Start Date: 19/06/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

\*280\*

QC

Quality Control

Memo

0.00

MLJ 12/08/08

Closed at zero

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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# Picklist Print

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Page 1

Work Order ID: 86008

Parent Item: D212-664-107

Parent Item Name: Crosstube Low Standard Fwd

**\*86008\***  
**\*D212-664-107\***

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 1.00

Required Qty: 1.00

**Comments:**

IPP Rev:A New Issue 07.09.12 EC verified by: JLM  
 IPP Rev:B ECN 1100 08-01-11 DD verified by: EC  
 IPP Rev:C Ecn 1121 08-02-25 DD Verified by:ec IPP Rev:D  
 10.05.27 added pick kit DD verf:EC IPP Rev:E 11.10.17  
 added SEQ 215 DD verf:EC IPP REV:F 11.11.03 as per  
 chg003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D212-664-107TRN		Manufactured	No			140	Each	0.0000	1	1			
<b>*D212-664-107TRN*</b>									<i>3 86052</i>	<b>**</b>	<i>SAD</i>	<i>10-07-24</i>	
Crosstube Turning Detail													
D3659-1		Manufactured	No			220	Each	9.0000	2	2			
<b>*D3659-1*</b>									<b>**</b>				
CUFF													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST482	9	
67005	1	
75173	1	
77032	7	

CR3212-4-06	Purchased	No		240	Each	202.0000	44	44	<b>**</b>	
<b>*CR3212-4-06*</b>										
CHERRY RIVET										

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST330	149	
120521	149	
ST331	53	
112492	18	
112794	8	
119717	27	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D212-664-107

Parent Item Name: Crosstube Low Standard Fwd

**\*86008\***  
**\*D212-664-107\***

Start Date: 19/06/2012

Start Qty: 1.00

Required Date: 03/07/2012

Required Qty: 1.00

D3595-063-450

Manufactured No

240

Each

147.5095

4

4

\*\*

**\*D3595-063-450\***

RUBBER CUSHION

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	27.7	
82511	27.7	
LG051	109.7	
80161	1.7	
84715	108	
MAT052	10 109474	
67353	2	
68893	6	
70113	0.56	
71354	0.2	
74113	0.349474	
75597	1	

MS21920-25

Purchased No

240

Each

99.0000

4

4

\*\*

**\*MS21920-25\***

Clamp(per MIL-DTL-8783C)

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG050	67	
116264	2	
117998	4	
118142	4	
119339	2	
119746	2	
120475	7	
120920	46	
LG051	32	
121583	32	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 86008

Parent Item: D212-664-107

Parent Item Name: Crosstube Low Standard Fwd

\*86008\*  
\*D212-664-107\*

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 1.00

Required Qty: 1.00

D2893-1

Manufactured No

240

Each

21 0000

2

2

\*\*

\*D2893-1\*

2.75 Support

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	9	
83056	9	
LG052	12	
72865	2	
80271	9	
82228	1	

D3428-1

Manufactured No

260

Each

35.0000

1

1

\*\*

\*D3428-1\*

Placard

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST042	35	
78933	2	
81881	11	
83582	10	
85228	12	

AN6-35A

Purchased No

260

Each

50.0000

4

4

\*\*

\*AN6-35A\*

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
342	50	
121181	50	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Picklist Print**

June-19-12 2:22:17 PM

Page 4

**Work Order ID:** 86008**Parent Item:** D212-664-107**Parent Item Name:** Crosstube Low Standard Fwd**\*86008\***  
**\*D212-664-107\*****Start Date:** 19/06/2012**Required Date:** 03/07/2012**Start Qty:** 1.00**Required Qty:** 1.00

AN6-36A

Purchased

No

260

Each

60.0000

4

4

**\*\*****\*AN6-36A\***

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST342	60	_____
118422	2	_____
119449	1	_____
120187	4	_____
120423	53	_____

MS21042L6

Purchased

No

260

Each

548.0000

6

6

**\*\*****\*MS21042L6\***

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	548	_____
117677	25	_____
118384	3	_____
118927	48	_____
119075	272	_____
120308	200	_____

AN960JD616

NAS1149D0663J Purchased

No

260

Each

0.0000

18

18

**\*\*****\*AN960JD616\***

Washer

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

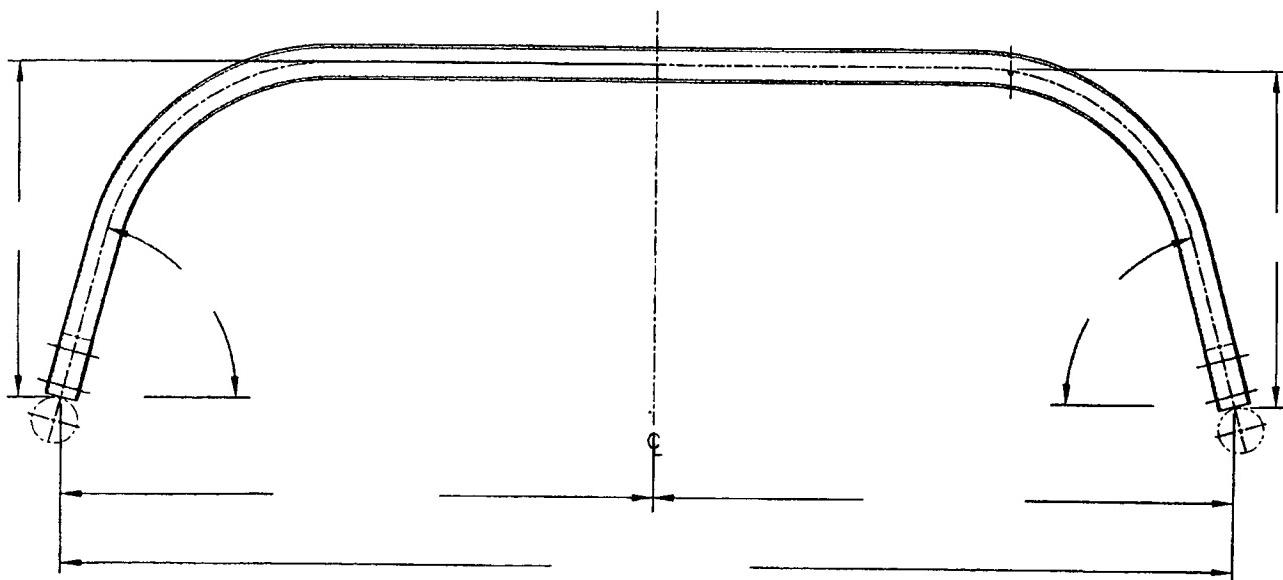
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	86008
Description: Crosstube Low Fwd (205/212/412)	Part Number:	D212-664-107
Inspection Dwg: D212-664-147 Rev: B		Page 1 of 1

Required Dimension	Min	Max
Height	20.79	21.05
1/2 Span	48.55	48.81
Angle	49	52
Total Span	97.1	97.62
Bending Passes	8	--
Crushing	--	6% / 10%



	Side A	Side B
Bending Passes		
Crushing		
Comments		

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	08.02.29	New Issue	KJ/JM	
B	10.01.21	Dwg Rev updated	KJ	
C	12.04.16	Added bending, crushing dimensions	KJ	JP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**B**

Item	Qty -147	Qty -147B	Part Number	Description
1	X		D212-664-147	CROSSTUBE ASSEMBLY (205/212/412 LOW FWD)
2		X	D212-664-147B	CROSSTUBE ASSEMBLY (214 LOW FWD)
3	1	1	D6015-128	CROSSTUBE
4	2	2	D2893-1	SUPPORT
5	4	4	D3595-063-450	RUBBER CUSHION
6	2	2	D3659-1	CUFF
7	4	4	MS21920-25	CLAMP (OR MS21920-26)
8	44	44	CR32124-06	RIVET (OR M7885/3-4-06)
9	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION R80-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
10	A/R	A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

**GENERAL NOTES:**

- 1) MATERIAL MANUFACTURED FROM D6019-128  
FINISHED LENGTH = 126.528±0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH, CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES .005 TO 0.010 MAX.
- 6) IDENTIFICATION SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUDD USING VIBRATING STYLUS.
- 7) WEIGHT D212-664-147 = 24.2 lbs (PER IN-D212-864)  
D212-664-147B = 24.2 lbs (PER IN-D212-664)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) WHEN MACHINING TAPER, RUN CUTTER OFF PART BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038
- 12) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 15 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 16) INSTALL D3659-1 CUDD AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUDD AND CROSSTUBE SEAL EDGE OF CUDD TO ENSURE NO GAPS
- 17) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO 86008 MLJ  
12/06/19

**DEO ATTACHED**

1 PER EQN #11.6.4F  
A 1107-26  
**UNDER REVIEW**  
GP 1108.13

**RELEASED**  
2009-10-29  
JW

B	REVISE GENERAL NOTES/PART LIST; UPDATE TO CURRENT STANDARDS; ADD -147B (ZN C4-2, D4-2)		RF	09.09.30
A	NEW ISSUE		CP	07.07.07
REV.	DESCRIPTION		BY	DATE
DESIGN	<i>Q</i>	<b>DART AEROSPACE LTD</b> HAWKSLEY, ONTARIO, CANADA		
DRAWN	RF	DRAWING NO. <i>D212-664-147</i> REV. B SHEET 1 OF 4		
CHECKED	<i>Q</i>	MFG. APPR. <i>DS</i>		
APPROVED	<i>NO</i>	TITLE <i>CROSSTUBE (205/212/412 LOW FWD)</i> SCALE <i>NTS</i>		
DE APPR.	<i>NO</i>	DATE <i>09.09.30</i>		

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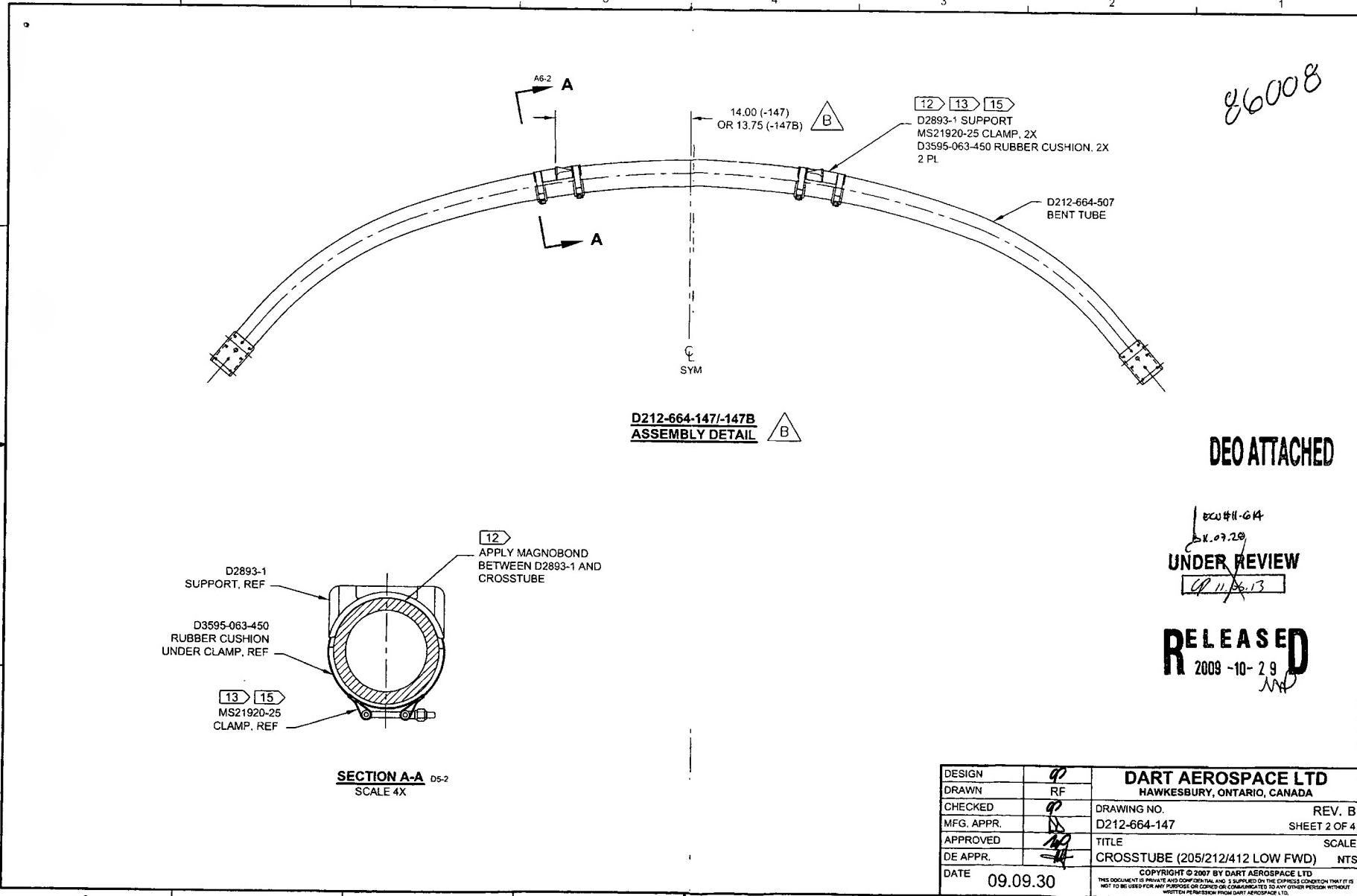
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



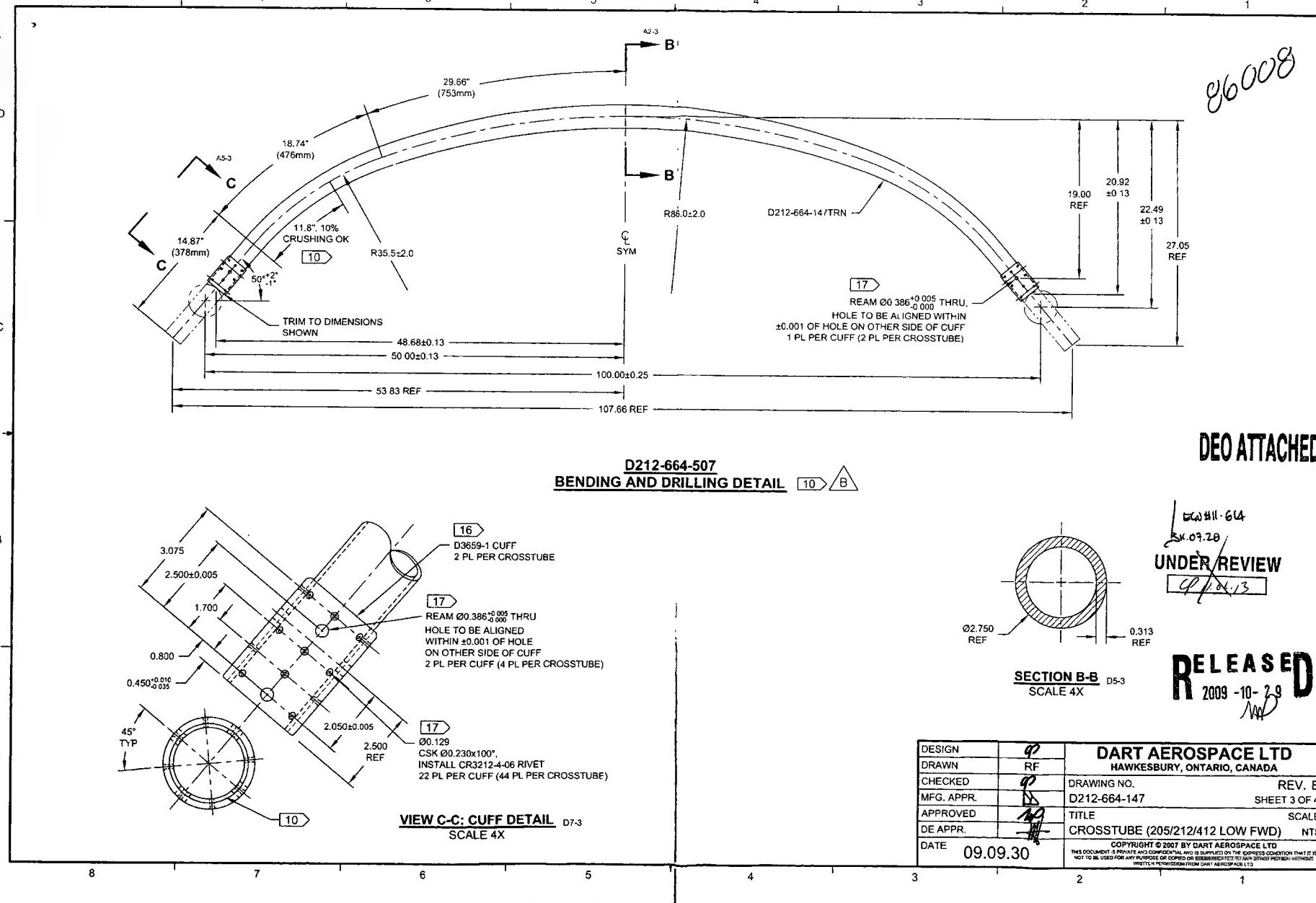
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



g6008

**DEO ATTACHED**

~~UNDER REVIEW~~  
GJ/06.13

RELEASED  
2009-10-29

DESIGN	<u>90</u>	DART AEROSPACE LTD		
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<u>90</u>	DRAWING NO.	REV. B	
MFG. APPR.	<u>DS</u>	D212-664-147	SHEET 3 OF 4	
APPROVED	<u>10</u>	TITLE	SCALE	
DE APPR.	<u> </u>	CROSSTUBE (205/212/412 LOW FWD) NTS		
DATE	09.09.30	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AND IS SUPPLIED PURSUANT TO A CONFIDENTIALITY AGREEMENT. NOT TO BE USED FOR ANY PURPOSE OR COPIED EXCEPT AS STATED IN THE STATED AGREEMENT.		

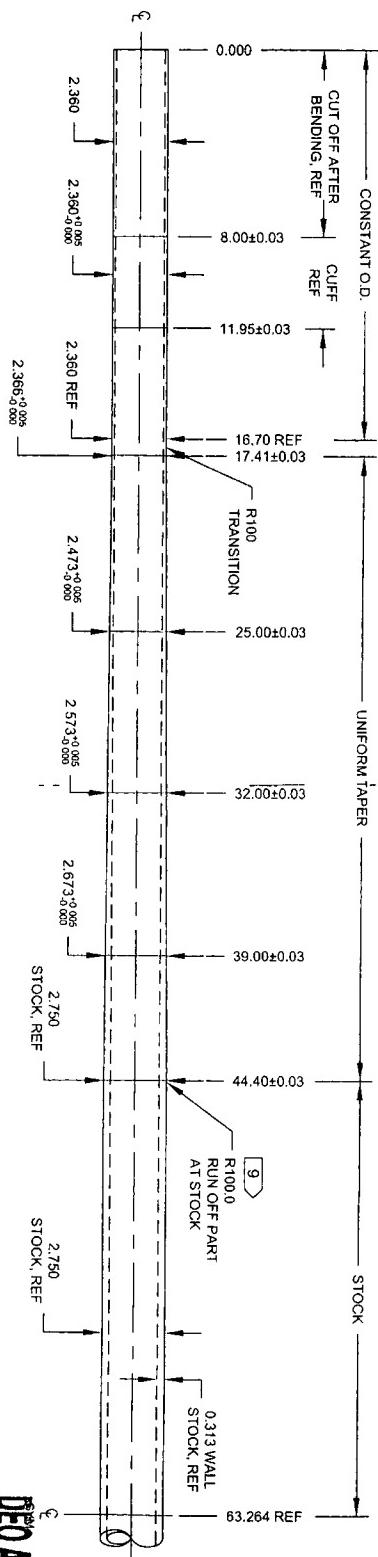
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



~~OCIO #1-614~~  
11-09-26  
~~UNDER REVIEW~~

**DETACHED**

**RELEASER**  
2009-10-29  
*[Signature]*

DESIGN	<b>Q</b>	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	<b>Q</b>	DRAWING NO.
MFG. APPR.	<b>Q</b>	2D12-664-147
APPROVED	<b>Q</b>	SHEET 4 OF 4
DE APPR.	<del>Q</del>	SCALE
DATE	09.09.30	NTS
CROSSTUBE (205/212412 LOW FWD)		
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W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D212-664-147	TITLE CROSSTUBE ASS'Y (205 LOW FWD)	REV. B	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D212-664-147-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q2</i>	CHECKED <i>ASS</i>	MFG. APPR. <i>PS</i>	APPROVED <i>MP</i>	DE APPR. <i>MM</i>		
DATE 11.07.15	DATE 11.07.20	DATE 11.07.21	DATE 11.07.24	DATE 11.07.24	DATE 11.07.24	

**PURPOSE:**

REPLACE MAGNOBOND WITH PROSEAL.

*g6008*

**CHANGE:**

IS:

Item	Qty -147	Qty -147B	Part Number	Description
9	A/R	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

9	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
---	-----	-----	----------------	---

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2893-1 SUPPORT: ABRADE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

WAS:

- 12) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O: 86052

## WORK ORDER CHANGES

## PROCEDURE CHANGE

DATE	STEP	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

~~REFERENCE ONLY  
COPY~~

Part No: D212-664-107TRN PAR #:

Resolution:

Fault Category: Manufacturing  
Disposition: Will not affect functionNCR: Yes  No  DQA:  Date: 12/07/24QA: N/C Closed:  Date: 12/7/24

## WORK ORDER NON-CONFORMANCE (NCR)

NCR: 12-1610	DATE 12/7/3	STEP 100	Description of NC Section A OVERALL CUT LENGTH TOO SHORT = 126.41 S.L. required 128	Corrective Action Section B		Verification Section C	Approval Chief Eng DAS 16 8-83	Approval QC Inspector 1st/Rev
				Initial Chief Eng CP 12-07-03	Action Description Chief Eng Acceptable. Cuff is trimmed after bonding so no effect on part			
						KL 12-7-03	GP 12-7-4	

NOTE: Date &amp; initial all entries

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

# **WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: Date:

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled
										<input type="checkbox"/> Other	